

Date: Tuesday, 11/21/2006 1:34:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 29615-1
 Estimate Number : 10532
 P.O. Number : N/A
 This Issue : 11/21/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 29498
 Part Number : K10003
 Drawing Number : K10003
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 12/5/2006
 Qty: 8 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est : J 06-07-25 As per DSI 9344
 JLM
 Est : K 06.11.17 Per K10003 Rev C
 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels for D205-634-011 and D204-635-011 per PPP K10003
 CHG005

2.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 288.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	B29620

3.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	B27992 5X B27887 6X

1X B26972

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT

Job Number: 29615

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

✓ 1

D2572

Saddle

B27923 9X

B28779 3X

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

* ✓

1

D2573

Saddle

B27889

FX

B27994 XY

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

✓ 1

D2574

Saddle

B27995

7X B28805 3X

7.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

✓ 1

D2736-1

Bracket

B28889

8.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

✓ 1

D2736-3

Bracket

B28015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT

Job Number: 29615

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

✓ 4

D2747

Socket Head Set Screw

B25011 -

10.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

✓ 2

D2876

Spacer

B26387 -

11.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

✓ 2

D2877

Spacer

B26513 21X -

3X B24481 -

12.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Tow Ring

Pick:

Qty

Part Number

Description

Batch

✓ 1

D2968-041

Tow Ring

B28267 8X -

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Set Screw

Batch:

B28032 -

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

✓ 16

AN4-6A

Bolt

M102602 -

15.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

✓ 4

AN4-46A

Bolt

M102114 -

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

✓ 8

AN4-51A

Bolt

M102536 -

17.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

✓ 8

AN6-12A

Bolt

M100188 -

18.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

✓ 32

AN960JD416

Washer

M102339 -

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 29615

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
✓ 8	AN960JD616	Washer	M10124-

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
✓ 1	AN970-4	Washer	M102380-

21.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 348.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
✓ 29	MS21042L4	Nut (or MS21042-4)	M19185-

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #1	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29615

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